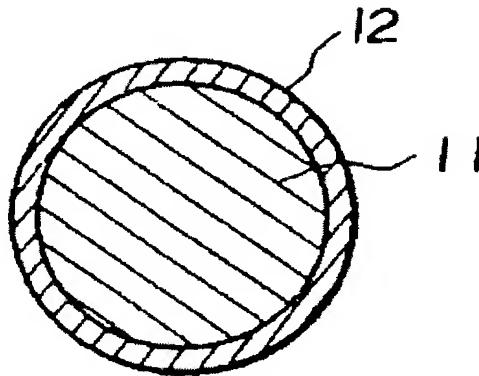


**ELECTRODE WIRE FOR WIRE ELECTRIC DISCHARGE MACHINING**

**Patent number:** JP61270028  
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**Applicant:** FUJIKURA LTD  
**Classification:**  
- **international:** B23H7/08; B23H7/08; (IPC1-7): B23H7/08  
- **european:**  
**Application number:** JP19850113685 19850527  
**Priority number(s):** JP19850113685 19850527

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PURPOSE: To improve a machining speed of an electrode wire and its break resisting property, by coating a steel wire core material, having a 10-70% coating rate of copper, with a 0.1-15μm thick copper-zinc alloy layer of mean zinc concentration of 10-50% by weight so that concentration of zinc increases higher toward the surface layer. CONSTITUTION: A copper coated steel wire 11 coats a steel wire with copper by a coating rate of 10-70%. The copper coated steel wire 11, providing in its peripheral surface with the wire 11 being as a core material a copper-zinc alloy layer 12 in a range of 0.14n15μm almost fixed thickness, forms the whole unit in about a 0.2mm diameter. The copper-zinc alloy layer provides means concentration of zinc in 10-50% by weight while a gradient of concentration so as to increase the concentration of the zinc higher from the copper ground toward the surface layer. While the steel wire 11, heat treating a zinc layer provided in a uniform thickness by zinc electroplating to be completely changed into the copper-zinc alloy layer, enables the copper-zinc alloy layer 12 almost in a uniform thickness to be obtained.



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